

QUALITY ASSURANCE PROVISIONS (QAP)
FOR THE
MK 14 MOD 0 SUSPENSION LUG

I. QUALITY SYSTEM REQUIREMENTS

- A. The contractor shall implement and maintain a quality system meeting the requirements of ISO 9002-1994 (or 9001-2000.) The quality system shall also implement the following provisions:
1. Subcontractors producing critical and/or major characteristics shall have a quality system compliant to ISO 9002-1994 (or 9001-2000.)
 2. When property is furnished by the Government, the contractor shall implement the following:
 - (a) Examination upon receipt, consistent with practicality, to detect damage upon transit;
 - (b) Inspection for completeness, quantity and proper type;
 - (c) Periodic inspection and precautions to assure adequate storage conditions and to guard against damage from handling and deterioration during storage;
 - (d) Identification and protection from improper use or disposition.
 3. Process and Production Control conditions shall include:
 - (a) Documented manufacturing planning for the implementation and control of manufacturing operations. The planning shall include: a description of operations, facility, environmental equipment, and tooling requirements, associated controls, and a process flow chart to portray the process of fabrication and assembly in terms of key operations.
 - (b) Accountability for all product.
 - (c) Evidence that all manufacturing, test, and inspection operations have been completed in sequence, as planned, or as otherwise documented and authorized.
 - (d) Preparation of documented process monitoring, accountability, and operator instructions for all processes that affect product quality. These instructions are to be accessible at the point where work is performed and shall, as a minimum, contain reference to the following: workmanship standards, manufacturing aids, step by step instructions for performing operations, equipment or tools required, special conditions to be maintained, identification of special handling devices, and methods for recording completion of operations.
 4. The contractor's calibration system shall be in accordance with ANSI/NCSL Z540-1-1994.
 5. Control of nonconforming material shall include:
 - (a) Controls applied to suspect product as well as to nonconforming product.
 - (b) The proposed use or repair of product which does not conform to specified requirements shall be submitted to the Government prior to use or repair. Rework and repair shall be in accordance with applicable contract clause. Repetitive nonconformances will not be approved.
 - (c) The contractor shall promptly notify the Government when a nonconformance is found in the contractor's processes or products that may affect product already delivered.
 6. Corrective action shall be required of a subcontractor when it is determined that the root cause of a nonconformity is the responsibility of the subcontractor.
 7. Internal audits shall cover all quality management related processes, activities, and shifts, and shall be scheduled according to an annual plan.
- B. The quality system shall be documented in a Quality System Plan (QSP) in accordance with the applicable CDRL, ADL and this PQAR. The QSP shall document the details of the contractor's quality system, including management commitment to quality, system elements, policy and practices. This Plan provides the Government a basis for assessment of the quality system and evidence of the contractor's intent to comply with the contract quality requirements.
1. The QSP shall include traceability from the specific quality requirement elements to the specific contractor processes which support those elements. The QSP shall include:
 - (a) A summary of the contract quality requirements and
 - (b) A relational matrix to indicate the general relationship between the contractor's quality system procedures/processes and the applicable quality system elements. The matrix, or an attachment thereto, shall also identify schedules or quality activities and tasks which must be coordinated and compatible with other schedules prepared for work under the contract, as well as include the name(s) of the person(s) responsible for accomplishments of activities and tasks.
 2. The QSP shall identify the means by which the contractor will ensure quality system effectiveness and demonstrate comprehensive management and review of data, such that the results may be used to

indicate trends and progress in quality of design, processes fabrication, assembly, test and acceptance as appropriate to the contract. The QSP shall describe what is measured, how often it is tracked, and who reviews and assures that appropriate action is initiated when trends are unfavorable.

3. A copy of the contractor's quality manual which describes the current quality system shall be attached.
- C. The contractor shall prepare an Acceptance Inspection and Test Plan (ITP) in accordance with the applicable CDRL and the following format:
 1. General format: The ITP shall, at minimum, contain the following:
 - (a) Cover sheet identifying item, contract number, and revision letter of the plan.
 - (b) All of the tests and inspections required for acceptance of the item, documented in accordance with the requirements herein.
 - (c) A section for gage and measurement equipment maintenance, recertification, and recalibration documented in accordance with the requirements herein.
 2. Format for documenting inspections: For each test or inspection, including those tests or inspections which are contained in specifications, specific instructions shall be prepared and shall contain the following:
 - (a) Identification of the item to be tested or inspected, including part number, revision letter, and nomenclature.
 - (b) Identification of measuring and test equipment using appropriate identification data which is visible on the equipment. Standard instruments such as a caliper or micrometer do not require a one to one identification description and can be identified simply as "caliper" or "micrometer".
 - (c) The location of the characteristic, such as the drawing sheet and zone, or a brief description of the characteristic such that an inspector can identify it's location.
 - (d) A written procedure for performing the test or measurement when the characteristic is other than a simple plus or minus tolerance dimension which is measured by the use of a standard instrument such as a caliper or micrometer. The procedure may be placed in an appendix of the plan and referenced if the procedure is lengthy or repeatedly used.
 - (e) The manner in which the result of the inspection is to be recorded such as a particular data sheet.
 - (f) Criteria for passing or failing the inspection (such as the high and low limit for a particular dimension, a particular minimum tensile strength, minimum voltage, etc.).
 - (g) Details of the sampling plan to be used.
 3. Format for gage maintenance, recertification, and recalibration schedule: For each acceptance gage, or other measurement device (including standard measuring instruments) used for final acceptance, the following information shall be documented in the ITP:
 - (a) A description of the gage or measuring device, including identification data which is visible on the equipment.
 - (b) A schedule for recertification of the gage or measurement device in terms of gage passes or time limit.
 - (c) Inspection and test equipment used for acceptance of CRITICAL and MAJOR characteristics shall require design approval in accordance with applicable CDRL. A copy of the approval shall be included. Inspection and test equipment used for acceptance of other characteristics (i.e., MINOR) shall require approval in accordance with applicable CDRL. A copy of the approval shall be included.

The above format shall be used for all required tests and inspections regardless of whether the tests or inspections are performed by a subcontractor. When tests or inspections are performed by a subcontractor, all of the above information shall be provided by the subcontractor or obtained by subsequent receipt test or inspection or final acceptance by the prime contractor. When tests or inspections are performed by a subcontractor, the prime contractor shall review the relevant specifications and create a receipt test or inspection review sheet to review the subcontractor's test and inspection data to ensure conformity to contractual requirements. In-process or statistical production tests or inspections, which are used for purposes of manufacturing material, which will later be verified by an acceptance test or inspection, need not be documented in the plan.

- D. Approved test and inspection equipment shall be made available for use by the Government when required to determine conformance with contract requirements. If conditions warrant, contractor personnel shall be made available for operation of such devices and for verification of their accuracy and condition.

II. INSPECTION REQUIREMENTS

Contractor, in performing sampling inspection of the product(s) being manufactured/delivered under this contract, shall, as a minimum, comply with the inspection requirements set forth below without jeopardizing quality:

1. Characteristics classified on the drawings or in separate documents as CRITICAL shall be inspected 100%.
2. Characteristics classified on the drawings or in separate documents as MAJOR shall be inspected by class of characteristics using ANSI/ASQC-Z1.4, AQL of .65.
3. Characteristics classified on the drawings or in separate documents as MINOR either LISTED or UNLISTED shall be inspected by characteristic using ANSI/ASQC-Z1.4, AQL 1.0.

Notes:

1. The above criteria will apply except where sampling plans and acceptance criteria appear in the product and/or affiliated specifications, or where authorization to deviate from the requirements of this clause has been obtained in accordance with contract requirements.
2. If the use of an alternate sampling plan (other than those specified above) is desired, it shall be documented in detail to show factors such as lot size, sample size, acceptance criteria, and operating characteristic curves, and submitted for approval in accordance with the contract requirements.
3. Characteristics other than product attributes-processing requirements specified on drawings which are classified as CRITICAL, MAJOR, MINOR, or UNCLASSIFIED are exempt from the inspection requirements of the plans above. However, these processes shall be controlled in accordance with the quality system requirements of the contract.
4. The designation of an AQL shall not imply that the supplier has the right to knowingly supply any defective unit of product.
5. Sampling in accordance with ANSI/ASQC-Z1.4 will use General Inspection Level II unless otherwise specifically allowed.

III. STATISTICAL PROCESS CONTROL PROGRAM

The contractor's implementation of the SPC program shall be documented in accordance with the applicable CDRL and contract clause (with scope of work).

IV. ACCEPTANCE REQUIREMENTS

A. First Article Inspection And Test:

1. First Article Inspection And Test: Unless otherwise specified in the contract or purchase order, the first article sample as specified below, shall be inspected and tested in accordance with the examinations and tests of these first article requirements. Unless otherwise specified in the contract or purchase order, the examinations and tests shall be performed by the contractor, under the observation of the Government QAR. The first article test and inspection results will then be verified by the Government procuring activity for conformance to contract or purchase order requirements. The contractor shall prepare a first article inspection and report for the examinations and tests performed on the first article sample. Upon completion of the first article verification (by the Government procuring activity) the contractor shall deliver the first article sample to the Government technical agency.
- 1.1 First Article Sample: Prior to the start of regular production, the contractor shall manufacture and submit a first article sample consisting of fifty (50) MK 14 Suspension Lugs using the methods and processes proposed for quantity production. The first article sample shall conform to all requirements specified by the contract or purchase order. Additional first article samples may be required by the Contracting Officer as the results of a first article sample failing to meet the contract or purchase order requirements. The contractor at his own expense shall supply additional first article Mk 14 Suspension Lugs required as a result of first article failure. Until the first article sample approval, further production shall be at the risk of the contractor. The Government will not proceed with inspection of the production lots (quality conformance inspection) until first article approval is granted.
- 1.2 Acceptance Of First Article Sample: If the first article sample passes the criteria established in the examination and tests specified herein, it will be approved. If the first article sample fails any of the examinations and tests specified herein, the results will be evaluated by the Government. These results,

together with the Government engineering analysis of the first article sample, shall form the basis for corrective action by the contractor. Depending upon the degree of corrective action deemed necessary by the Government, first article approval may be:

- (a) Granted, in which case the contractor shall have first made the changes required by the Government prior to the start of regular production.
- (b) Withheld, and new MK 14 Suspension Lugs shall be submitted for approval in place of the failed MK 14 Suspension Lugs of the first article sample. The MK 14 Suspension Lugs shall be subjected to the examinations and tests in which the failures occurred and any other examinations and tests of the first article as required by the Contracting Officer.
- (c) Withheld, and a new first article sample shall be submitted for approval. In all cases the contractor shall comply with the required changes which are within the scope of the contract or purchase order requirements to the satisfaction of the Government for future production.

1.2.1 Reinstitution Of Tests Or Inspections: Acceptance of first article sample shall not relieve the contractor from meeting all contract or purchase order requirements throughout the life of the contract or purchase order. When evidence shows failure to continue to meet the first article requirements specified herein, the Government reserves the right to require tightened test or inspection on a lot basis, consisting of the reinstitution of such portions of the first article needed to verify the effectiveness of any corrective action.

1.3 Supplemental First Article Sample: An additional first article sample or portion thereof may be required by the Contracting Officer in writing when:

- (a) A major change is made to the technical data package.
- (b) Whenever there is lapse in production for period in excess of ninety (90) days.
- (c) Whenever a change occurs in the manufacturing process, material used, drawings, specification, source of supply, process location or inspection processes being performed.

When conditions (a), (b) or (c) above occur, the Government procuring activity shall be notified, in writing. Written approval from the Government procuring activity shall be required prior to the implementation of any of the aforementioned scenarios. Costs of the first article test and inspection resulting from (a), (b) or (c) above shall be borne by the contractor.

1.4 Materials, Design And Construction: Materials, design and construction of the MK 14 Suspension Lugs shall be in accordance with the requirements as defined by the contract or purchase order. The contractor shall demonstrate by means of certification that only materials and components conforming to the contract or purchase order requirements have been used. Certification statements shall completely identify the material or component, indicate the specification or drawing (revisions and dates) applicable, the grade or type to which the material or components were tested, the number tested and quantitative requirements and results obtained during tests. The required data may be from the specific quantity of material or components used in the contract or purchase order or from the manufacturing lot from which the material or components originated.

1.5 First Article Inspections And Tests: Prior to the submission of the first article sample for verification by the cognizant Government procuring activity, the contractor shall inspect and test the first article sample to assure that it conforms to the requirements of the contract or purchase order. Each suspension lug shall be subjected by the contractor to all examinations and tests required by the contract or purchase order. The contractor shall prepare and provide documentation with the first article sample identifying all inspections and tests performed and their results. This documentation along with first article sample will be verified by the cognizant Government procuring activity to determine compliance to contract or purchase order requirements.

1.5.1 First Article Test Verification: The first article verification sample shall consist of fifty (50) MK 14 Suspension Lugs conforming to all drawing requirements and accompanied by inspection results as well as certified test reports required by contract or purchase order. The first article verification sample shall be divided into two samples A and B. Sample A shall contain twenty (20) unplated lugs and sample B shall contain thirty (30) plated lugs.

Sample A:

- 1. All MK 14 Suspension Lugs shall be subjected to magnetic particle inspection in accordance with Drawing 1555268, Sheet 1, Note 3.

2. All MK 14 Suspension Lugs shall be hardness tested in accordance with Drawing 1555268, Sheet 1, Note 4A.
3. Ten (10) MK 14 Suspension Lugs shall be subjected to the tension test In accordance with Drawing 1555268, Sheet 1, Note 4B(1).
4. Ten (10) MK 14 Suspension Lugs shall be subjected to the tension test In accordance with Drawing 1555268, Sheet 1, Note 4B(2).

Sample B:

1. Five (5) of the MK 14 Suspension Lugs shall be subjected to salt spray testing in accordance with Drawing 1555268, Sheet 1, Note 2D.
2. The remaining twenty five (25) MK 14 Suspension Lugs will be dimensionally inspected for conformance to contract or purchase order requirements.

1.5.2 First Article Inspection Verification: During the Government procuring activity first article verification, the contractor's gauges and other measuring and test devices necessary to assure that supplies conform to the contract or purchase order requirements will be reviewed. The Government procuring activity reserves the right to perform any of the inspections set forth in the contract or purchase order requirements as necessary to assure supplies conform to these requirements. This shall included but not be limited to the use of Government operated inspection laboratories. The contractor's measuring and test equipment shall be made available for use by the Government representatives to determine conformance to contract or purchase order requirements. In addition, contractor's personnel shall be made available for operation of such devices and for verification of their accuracy.

1.5.3 Certifications: The contractor's certifications shall be reviewed for conformance to drawings, specification and contract or purchase order requirements.

1.5.4 Process Controls: The process controls and procedures of the contractor's inspection system will be reviewed for conformance to specifications and contract or purchase order requirements.

- B. Lot Acceptance Inspection And Test: Lot acceptance inspection and testing shall be conducted by the contractor under the observation of the Government QAR. Lot acceptance shall be conducted in accordance with Drawing 1555268 and this QAP.
- C. First Article And Lot Acceptance Reporting: At conclusion of first article and lot acceptance inspection and testing, the contractor shall prepare test reports in accordance with CDRL requirements.
- D. Quality System Review: A quality system review concurrent with first article or first lot acceptance may be conducted to evaluate the contractor's quality system, processes and procedures inherent to the quality of items to be delivered under this contract. The review shall be conducted by Government representatives designated by the Contracting Officer.

V. TEST AND INSPECTION REDUCTION OR ELIMINATION

- A. The Government will consider reduction or elimination of selected acceptance test or inspection based upon first article, preproduction, and lot acceptance test results when supported by evidence of both process stability and capability. Contractor written requests shall be made through the Administrative Contracting Officer to the Contracting Officer. Approval will be based upon the contractor's quality system plan, statistical process control plan, and validation of the implementation of statistical process control techniques and corresponding results. Upon approval by the Contracting Officer, acceptance shall be based upon the approved contractor's statistical process control program and associated statistical techniques.
- B. The Government will not consider requests for reduction or elimination of 100% acceptance inspection and testing of parameters or characteristics identified as CRITICAL.
- C. The Government will consider reduction or elimination of acceptance inspection or test requirements when the following conditions are satisfied:
 1. For parameters and characteristics other than CRITICAL when evidence is provided of statistical control and a Cpk of at least 1.33.

- 2. Objective evidence that statistical control and Cpk continue to be evaluated and maintained.
- D. Evidence of loss of statistical control or degradation below a Cpk of 1.33 shall require immediate corrective action in accordance with the statistical process control program.
- E. Any break in production greater than 90 days shall require a return to normal acceptance inspection and testing.

VI. DOCUMENTATION REQUIREMENTS

- A. Required documentation (e.g., QSP, ITP, SPC) shall be submitted in accordance with applicable CDRL. The contractor shall be responsible for any delays resulting from late submittals or delays resulting from submittal of inadequate documentation.
- B. Documentation shall be maintained and updated as necessary. Updates (changes/revisions) shall consist of notes or changes, clearly identified as to where applicable (i.e., system element, page, paragraph number, etc.) Updates shall be submitted in accordance with CDRL requirements.

VII. ADDITIONAL REQUIREMENTS

- A. ECPs, VECs, Deviations, and NORs shall be prepared and submitted in accordance with applicable CDRL.
- B. Class II Approval Authority: The Government procuring activity (NAWC WD, Ft. Mugu) shall have Class II approval authority. Class II requests should be approved or disapproved within thirty (30) calendar days of receipt by the Government procuring activity.
- C. Production Progress and Delivery Report (DD Form 375) shall be prepared with instructions listed thereon.
- D. Contractor shall prepare Ammunition Data Cards in accordance with CDRL and deliver with each deliverable lot.
- E. Magnetic Particle Inspection Procedures: The magnetic particle inspection procedures shall be prepared and submitted in accordance with ASTM E1444 and Drawing 1555268 requirements. Procedures shall be submitted thirty (30) days after contract award to ensure sufficient time for Government review and approval prior to FAT (if required) or initiation of production if FAT is not required. Allow thirty (30) calendar days for Government review and disposition..